

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015453**Date Inspected:** 01-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG COMPONENT				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) for Segment 11AE

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as Segment 11AE joints.

The weld designation reviewed is as follows:

SEG066A-004,007
SSD19A-PP95-002,007
SSD19A-PP96-002,003,007
SEG066*-006~010
SEG066*-27~034
CSD07-PP96-001,019,021,039,051,145,147,149
CSD06-PP97-65,67

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 11AE, this Quality Assurance Inspector (QA) discovered the following issues that One (1) longitudinal

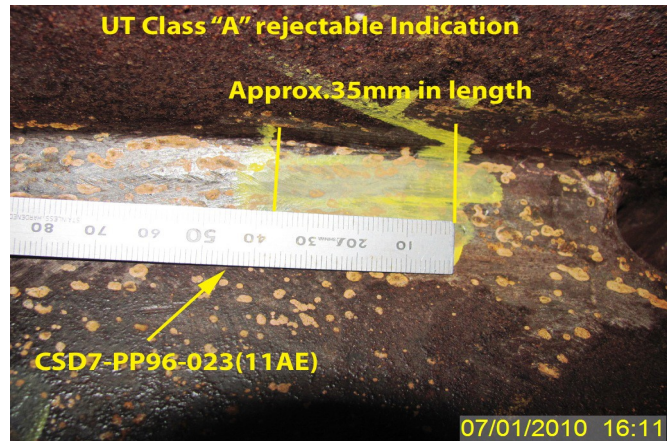
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linear indication measuring approximately 20mm in length. The indication db's rating is a +4. Material thickness is 35mm. The depth of the indication is approximately 12mm. The weld is identified as CSD7-PP96-023 at Bike Path Side, Panel Point PP96. The weld was fillet weld according to approved shop drawing but due to excessive root gap ZPMC changed to Complete Joint Penetration (CJP) "T" joint. The joint joining between Corner Assembly Diaphragm (X151C) to Edge plate EP170A (PL1406A). The weld is designated as Seismic Performance Critical Material (SPCM). The indication is clearly marked on or near the weld. The Y distance for this indication is 35 mm from bottom cope hole. Segment 11AE is located at outside near trial Assembly Area. The Notice of Witness Inspection (NWIT) No. is 006079. The indication is located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

The QA Inspector generated an incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera, Subhasis

Quality Assurance Inspector

Reviewed By: Patterson, Rodney

QA Reviewer